

Work Order ID 96360

January-25-13 10:23:00 AM

96360

Page 1

Item ID: D3027-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clip

Start Date: 1/25/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/01/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 13-01-25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3027

Rev B

110

0.00

110

~~HAAS CNC VERTICAL MACHINING #1~~

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT AS PER DWG

DWG REV: B

PROG REV: B

Grain Direction!!

DEBURR

12 0 Jm 13-3-27

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

12 0 Jm 13-3-27

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 5m 13.32J				12			
140 *140* Brake NC Brake NC	Small Fab Memo FORM AS PER DWG	0.00 0.00				12			88 13/04/02
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 5m 13.9.2				12			

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N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

170 QC3- Inspect Part Finish

0.00

170

QC

Memo

0,00

Quality Control

180 Identify as per dwg & Stock Location: 8T024 0.00

0.00

180

Packaging

Memo

0.00

Packaging

12x ———— 8p
1348

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Item ID: D3027-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clip

Start Date: 1/25/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 2/01/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

13/4/8 J

Picklist Print

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Page 1
T

Work Order ID: 96360

96360

Parent Item: D3027-1

D3027-1

Parent Item Name: Clip

Start Date: 1/25/13

Required Date: 2/01/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP B01.09.18Now goes on HAASSM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

203.8400

0.0277

0.249895

M2024T3S 063

**

0.4

Jm133.27

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

203.84

119916

0.2

121197

21.34

123096

11.4

123654

12.8

123701

158.1

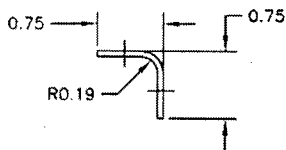
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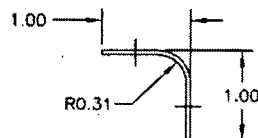
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DATE 05.09.20		TITLE CLIP	SCALE 1:2
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B	05.09.20	REMOVE HOLES FROM -7	

RELEASED

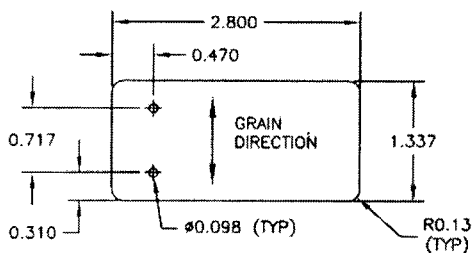
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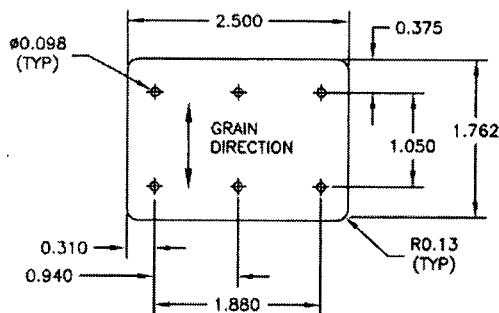
D3027-1 BEND DETAIL



D3027-3 BEND DETAIL



D3027-1 FLAT PATTERN
(0.063" SHEET)



D3027-3 FLAT PATTERN
(0.050" SHEET)

NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

96360-MC
B-01-25

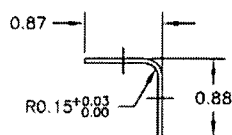
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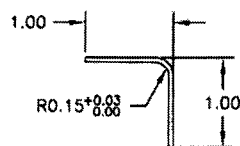


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DATE 05.09.20		TITLE CLIP	SCALE 1:2

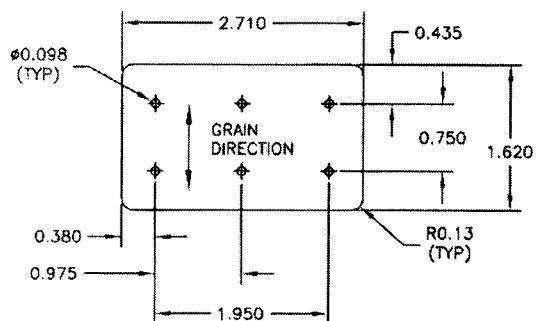
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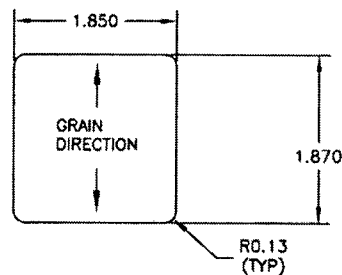
D3027-5 BEND DETAIL



D3027-7 BEND DETAIL



D3027-5 FLAT PATTERN
(0.050" SHEET)



D3027-7 FLAT PATTERN
(0.050" SHEET)

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